

Date: Friday, 6/23/2006 2:37:33 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACERS (5/16 THICK)	
Job Number	: 25967		Part Number	: D2022103	
Estimate Number	: 10248		Drawing Number	: D2022 REV. --	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 6/23/2006	S.O. No. : N/A	Drawing Revision	: -	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: 2/27/2006	Type : MACHINED PARTS	Due Date	: 3/20/2006	Qty: 100 Um: Each
Previous Run	:				
Written By	: <u>See Comment Below</u>				
Checked & Approved By	: <u> </u>				
Comment	: Est D 02.03.07 Now made in house NG				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0750	6061-T6 Round Bar .750"	
		Comment: Qty.: 0.0329 f(s)/Unit Total : 3.2865 f(s) 6061T6 Round Bar .750" Material: 6061-T6 (QQ-A-225/8)x.750Ø bar (M6061T6R0.750) Batch: M100SS9 166 MS 06/06/25	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL 1- Note: .323 (P) Dia drill. 2-Turn Blank as per FolioFA207 3-Tumble & deburr any sharp edges as per dwg	SAD 06/06/06 183 M.F. 06/06/30 MS 06/06/25 183
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	MS 06/06/25 183
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	S.G 06/07/07 181
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST17	ST17 (181)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

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Seq. #: Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/07/07

Job Completion



06/07/07

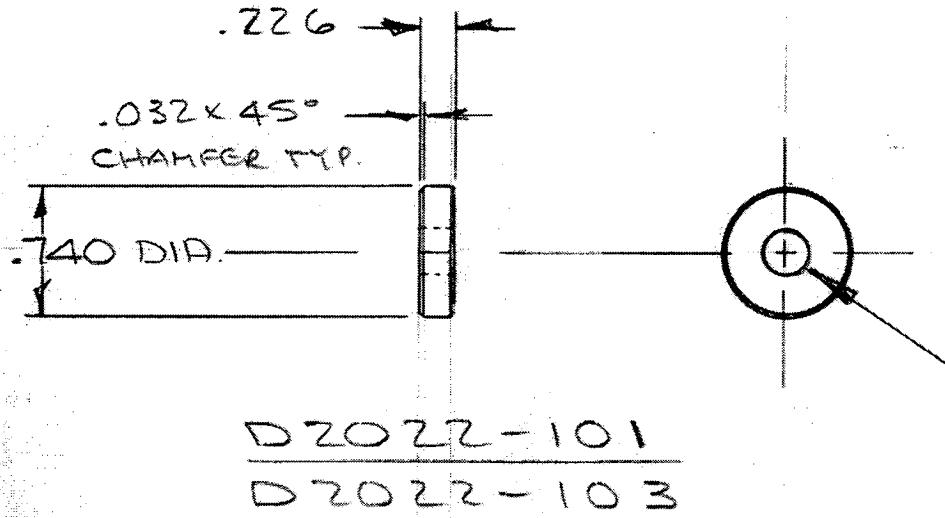
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

RELEASED
17/01/19 BW



REFERENCE ONLY

DRILL 'F' (.257) DIA. IN - 101
DRILL P (.323) DIA. IN - 103

MAT'L : ALUMINUM 6061-T6 (QQ-A-225/8)

1 COPY
SERIAL NO. 122022

REVISION	THE DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER MIL-S-523	GTY. REQUIRED	PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
DRAWN			BASIC CODE	DIA. DASH NO. W/NHEAD NEAR SIDE W/NHEAD FAR SIDE	APPROVAL	CONTRACT NO.	DART AERO ACCESSORIES INC		
APPROVED			GENERAL	NUMBER OF SHEETS COUNTERSINK		DRAWN BRADLEY	DATE 10/08/19	CLIENT	
DESCRIPTION OF CHANGE	REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		LIMITS	NUMBER OF SHEETS COUNTERSINK		DESIGN BRADLEY	10/08/19	TITLE	
	1. DIMENSIONS ARE IN INCHES. 2. SURFACE ROUGHNESS $\frac{1}{16}$. 3. REMOVE SHARP EDGES .015 MAX. 4. THICKNESS PERMILLE .5-.7742 5. HOLES PER INCH 1000 6. ALL M/C CENTRE LINES .005	1. TOLERANCES - .701 ± .000 2. ANGLES - .001 ± .010 3. PARALLELISM - .00025 4. CYLINDRICITY - .006 MAX. 5. SYMMETRY ANGUL - .006 MAX. 6. ALL M/C CENTRE LINES .005		BASIC CODES BJSMS20470AD BJSMS20480AD		STRESS		SPACERS	
	REPORT ALL DISCREPANCIES - DO NOT SCALE					CHECKED		CODE	DWG NO.
						CLIENT		REV.	D2022
								SCALE	1:1
								SHT	1 OF 1

DART AEROSPACE LTD	Work Order:	25967
Description: SPACERS	Part Number:	D2022-103
Inspection Dwg: 022 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	MS	Audited by:	981	Prototype Approval:	WIA
Date:	06/06/25	Date:	06/06/25	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	